



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D1048

Job Sheet 168299



Part No: D1048

Job Qty: 10 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/19/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP: B 02.02.22 Re-format NG IPP Rev:C Now on Waterjet 06-12-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/18/17	11/18/17	0.00	0.00	Start Up Waterjet		<i>DL 17/12/22</i>
100	Waterjet	10 pcs	11/18/17	11/18/17	0.00	0.27	Waterjet1		<i>DL 17/12/22</i>
120	QC	10 pcs	11/18/17	11/18/17	0.00	0.00	QC8		<i>38</i>
130	Small Fab	10 pcs	11/18/17	11/18/17	0.00	0.30	Small Fab		<i>38 DAS</i>
140	Brake NC	10 pcs	11/18/17	11/18/17	0.00	0.29	Brake NC 1		<i>38 DAS</i>
150	QC	10 pcs	11/18/17	11/18/17	0.00	0.00	QC5		<i>9-88 38</i>
160	Powdercoat	10 pcs	11/19/17	11/19/17	0.00	0.08	Powdercoat4		<i>BR 18-01-39</i>
170	QC	10 pcs	11/19/17	11/19/17	0.00	0.00	QC3		<i>38</i>
180	Packaging	10 pcs	11/19/17	11/19/17	0.00	0.00	Packaging3		<i>AT 17-01-10</i>
190	QC21-SA	10 Ea	11/19/17	11/19/17	0.00	0.00	QC21		<i>38</i>

Part Op 100 - 1-Cut as per Dwg D1048 Prog Rev: *A*

Descriptions: 130 - 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

140 - Form as per dwg using DT10143

160 - START TIME: *1:55* OVEN TEMPERATURE: *300°* FINISH TIME: *2:25*

M 135H18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	45	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches ± 0.010	0.760 0.740		
2	Clamp	2.175Inches ± 0.010	2.185 2.165		
3	Clamp	1.755Inches ± 0.010	1.765 1.745		
4	Clamp	0.375Inches ± 0.010	0.385 0.365		
5	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

Plex 11/14/17 7:48 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																															
Large Fab ☐	Composite ☐	Supplier ☐																																
S026521 DART AEROSPACE Clamp		QTY Effective : _____ Disposition		MRB (QSI042) Approval																														
				Completed By																														
				Lead hand / Supervisor Approval Verification																														
				QC / QA Coordinator Approval																														
Start up Operation Part NO: D1048 Revision: _____ Operation: _____ Change No: _____		FAULT CATEGORY <table style="width: 100%;"> <tr> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Countersink	☐ Off-set	☐ Drawing	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong																																
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions																																
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance																																
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect																																
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																
☐ Contamination	☐ Out of Sequence	☐ Part Moved																																
☐ Countersink	☐ Off-set	☐ Drawing																																
☐ Cut Too Short	☐ Mislabeled	☐ Finish																																
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Mfg Date: 12/22/17
Job No: 168299

Environ ☐

Doc ☐

Equip/T ☐

Handli ☐

Internal Tr ☐

Tribal Kn ☐

S ☐

Past Ex, ☐

Misidentified ☐

Past Due ☐